Work Order <i>May-27-13 12:42:</i>			*102	276*				· · · · · · · · · · · · · · · · · · ·		Page 1
Revision ID:	2324-5 rap		Accept	*N900	040	100)* s	Setup Start	I VI	S1* S2*
Required Date: 5/	27/13 Start Qty: 6.00 31/13 Req'd Qty: 6.00	*6* 16	20 *	Cust Item Customer:						·
	Process Plan: MLD				eate:		, F	Run Start	1/1	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr				A 18 18 18 18 18 18 18 18 18 18 18 18 18					
D2324	Rev C									AND AND AND ADDRESS OF THE PARTY OF THE PART
100 *100* Waterjet	FLOW WATER JET		0.00				20	0		Ac 13.09.03
FLOW CNC Waterjet		per Dwg D2324 Dwg Rev:_ necessary	Prog Rev:	<u>2</u> 2-						
*110	QC2- Inspect parts off	machine FAI/FAIB	0.00				- 1	J		1
QC Quality Control	Memo		0.00				20			Az 13.09.2
*120 *120*	QC8- Inspect parts - so	econd check	0.00 DAS 27 9-89				<i>≫</i>			
QC	Memo		0.00	\sim 2-						

Quality Control

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:
•	

										4.00	QA Closed:	Date	2:
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Part N	- - No					Rework Scrap Use-as-is Work Order Update		f Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
IIICK I	•••					Work Order opdate	۱ ۱		Large rab	· composite	J	Supplie!	
Root					Descri	ption of work order update	•	nitial	Ac	tion	Sign &		
Cause	\bot	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data	Ш												
Equip/Tooling	Ш												
Operator	Ш	:											
Material							l					ε	
Setup													
Other	Ш												
Process	Ш												
Supplier	i.	:			,								
Training	Ш												
Unapproved			ļ	<u> </u>									
				 			AUL	T CATE	GORY		·		
Landii					_	General		l			1	_	¬
	-	Bending				Bend	-	Grain			Ovalized		Pressure/Forced
	-	Centre No	ot Concer	ntric to	o/s _	BOM/Route	\vdash	Hardwa			Over/Under	 	Temperature/Cure
	-	Cracks			ļ	Broken/Damaged	\vdash		on Incomplete		Part Incorred	_	Weld
	Н	Crushed/0	Crimped		<u> </u>	Burrs	\blacksquare	1	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	${f H}$	Cuffs				Contamination	-	Mainte		<u> </u>	Part Moved		
		Heat Trea				Countersink	\vdash	Mislabe		<u> </u>	Positioned V		¬
	-	nspection	-	Tube	<u> </u>	Cut Too Short	-	Misread	i		Power Loss/	Surge	Other
		Ripples in				Drill Holes	\vdash	Offset					
	Н	Torque W			n	Drawing	\vdash	4	Calibration				
	-	Turning S	-		ļ	Finish	-	i	Sequence				
1	. 11	Mave/Tw	ict in Tub	10	1	Folio	1 1	Mutcida	Dimensions				

Work Ord <i>May-27-13 12</i>		02276		*102				Page 2				
Item ID: Revision ID: Item Name:	D2324-5 Strap			Accept	*N900	040	100)*	Setup	Start Stop	14.	S1* S2*
Start Date: Required Date Reference:	5/27/13 e: 5/31/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*	1.7.	Cust Item I Customer:	D:			*	٠		•
Approvals:		lan:	Date:			nte:			Run	Start Stop	"IVI	R1* R2*
Sequence ID/ Work Center 130 *120* Packaging Packaging	iD	Operation Description Identify as per dwg & Sto	ck Location (A	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty	t Re Qt	•	Reject Number	Insp. Stamp
140		QC21- Final Inspection -	Work Order Release	0.00					ı۸	ĵ		

0.00

Memo

140

Quality Control

HJ /12/3-09-24 NB 09-24

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-O	100	NFORM	MANCE / UP	DATE			
										QA Closed:	Date:	
Work Orde	·				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIR OTUC	' -				Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	0.				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	1	1	noforming	Finishing	-	re/Packaging	Other
NCR N	o				Work Order Update]		Large Fab	Composite]	Supplier	
Root	<u> </u>	<u> </u>	1	Descri	ption of work order update		Initial	Δα	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	1	nief Eng		ription	Date	Verification	QC Inspector
Doc/Data	1 3410	- CLOP	~,,		or real communication							до шороско.
Equip/Tooling												
Operator												
Material												
Setup	7	ļ				Ì						
Other						l						
Process												
Supplier												
Training												
Unapproved												
					F	AUL	T CATE	GORY				
Landin	g Gear				General		_			_		_
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks		•		Broken/Damaged	L	Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
[Heat Trea	at			Countersink		Mislabe	led		Positioned V	Vrong	_
	Inspectio	n Strip in	Tube	· [.	Cut Too Short	Г	Misread	l		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

Picklist Print

May-27-13 12:42:43 PM

Work Order ID:

102276

Parent Item:

D2324-5

Parent Item Name:

Strap

Start Date: 5/27/13

Required Date: 5/31/13

Page 1

Start Qty: 6.00

Loc Code

Required Qty: 6.00

Comments:	IPP E03.02.28Ref	ormat; Incorporat	ed D2324	-3 & D2324-5	KJ/RF								
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	446.0842	0.0184	0.1104		1 , ,	. @ .
304/316 Sheet .063											/	<u>e / S</u>	· 0 / · J

Location	Loc Oty
MAT020	446.0841688
122245	0.1713688
123136	140.8
124428	23.61
124572	25.5028
125599	256

m 126915

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFOR	MANCE / UPDATE				•
											QA Closed:	Date:	
Work Ord	<u>.</u>					DISPOSITION		*	AG	AINST DE	PARTMENT	/PROCESS	
Work Ordi	е.				······································	Rework	ר '		Skid-tube Cros	stube]	Water Jet	Engineering
Part i	No.					Scrap	1		—	all Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	1	Thern	noforming Fin	ishing	4	re/Packaging	Other
NCR I	No.		·		<u> </u>	Work Order Update]		Large Fab Com	posite]	Supplier	
		<u> </u>		ı			_				T 6' 0		
Root				_	i	ption of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty	<u> </u>	or Non-conformance	1 Cr	nief Eng	Description	_	Date	Verification	QC Inspector
Doc/Data			j .										
Equip/Tooling	$oxed{oxed}$												
Operator		ļ ;											
Material												:	
Setup													
Other													
Process		Ì	-		, ,								
Supplier	Г]	1			•							
Training		1					1						
Unapproved			ļ						•				
					•	·	AUI	LT CATE	GORY				
Landi	ing (Gear				General					_		_
		Bending				Bend	Г	Grain			Ovalized		Pressure/Forced
1		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct 「	Weld
	Crushed/Crimped Burrs				Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing .	Wrong Stock Pulled	
	Cuffs Contamination					Maintenance Part Moved			-				

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	107276
Description: Strut	Part Number:	D2324-5
Inspection Dwg: D2324 Rev: C		Page 1 of 1

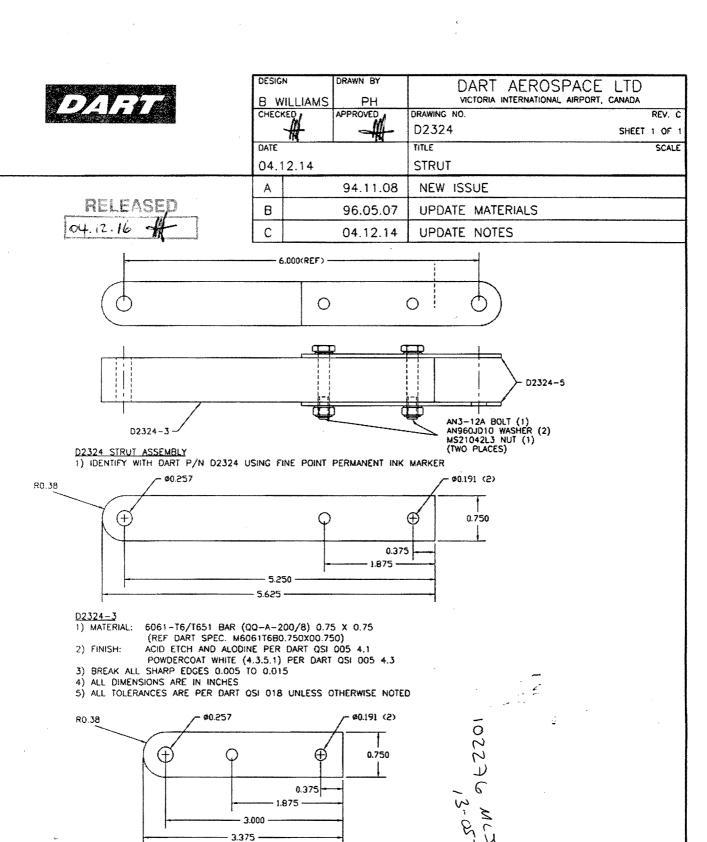
FIRST ARTICLE INSPECTION CHECKLIST

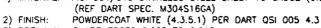
X	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.38	+/-0.030	.38	•		RG	
Ø0.257	+0.006/-0.001	.257	-		V	UKM-01
Ø0.191	+0.005/-0.001	.191	-		. V	
0.750	+/-0.010	760			V	
0.375	+/-0.010	.375	-		V	115000
1.875	+/-0.010	1. 875	•		>	
3.000	+/-0.010	3,000	-		V	
3.375	+/-0.010	3,380			٧	
			DAS			

			27		
Measured by:	Ae	Audited by:	9-89	Prototype Approval:	N/A
Date:	13.09.23	Date:	13923	Date:	N/A

Rev	Date	Change	Revised by	Approvéd
Α	06.06.05	New Issue	KJ/JLM A	911





3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

D2324-5
1) MATERIAL:

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)